

January 5, 2010 1:21:50 PM

Item ID:

D3928-1

Accept

Setup Start



Stop



**Revision ID:** Item Name:

**Start Date:** 

Bracket

Required Date: 15/01/2010

05/01/2010

Start Qty: 8.00. Req'd Qty: 8



Cust Item ID: 🖓 🕳

**Customer:** 

Reference:

Approvals:

Date://>/-/05

Tooling:

Date:

Start Run



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours**  Draw Number Draw Plan Code

Rev.

Accept Qty

Reject Qty

Number Stamp

Draw Nbr

**Revision Nbr** 

D3928 Rev A

0.00

100

Wateriet

Memo

0.00

B 10-1-11

FLOW CNC Waterjet

1-Cut as per Davg D3928 Dwg Rev: Prog Rev:\_\_\_

\*\*\*grain along 4.97"\*\*\* 2-Deburr if necessary

=7 m. A 10/01/13

110

QC2-Inspect parts off machine FAI/FAIB

0.00

出10-1-11

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
ı											

Part No:		_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	
	Resolution:		Disposition:	QA: N/C Closed	d:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
							·				



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Setup Start

Stop



Revision ID:

Item Name: Bracket

**Start Date:** 

05/01/2010 Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Draw

Number



Reference:

Approvals:

Required Date: 15/01/20

Process Plan: Date:

Tooling:

Date:

Start



QC:

Date:

SPC (Y/N):

Date:

Step



Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Set Up/ **Run Hours** 

Rev.

Plan Code

Reject Accept Qty Qty

Run

Number Stamp

0.00

130

Brake NC

Brake NC

0.00

0.00

So Idoila7

140

OC5- Inspect part completeness to step on W/O

1- Bend as per dwg

0.00

2) Enolar 127

Quality Control

Memo

0.00

W/0:55	5033	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
16/1/13	也 170	Took aly 11 For Ocenspection template	5	whis	4	W	10/1/13		

Part No: <u>D3928-1</u>	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			Approval	Annanal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspecto			
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January 5, 2010 1:21:50 PM

Item ID:

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Accept

Setup Start



Stop

Item Name: Start Date:

**Revision ID:** 

Bracket

05/01/2010 St rt Qty: 8.00

Cust Item ID: sistomer:

Reference:

Process Plan: Approvais:

Date:

Tooling:

Date:

Start



Required Date: 15/01/2010 | eq'd Qty: 8.00

Date:

SPC (Y/N):

Set Up/

Date:

Rev.

Stop

Reject

Qty

Number Stamp

Sequence ID/ **Work Center ID** 

150

**HandFinish** 

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

**Run Hours** 0.00

10-01-28

Draw

Number

Accept

Qty

Code

Run

160 Powdercoat

**Powder Coating** 

White Gioss(Ref:4.3.5.1) per QSI005 4.3-Alum

11113170

Memo Start Time: 1:45pm Oven Temperature: 320°1 Finish Time: 2:1500

0.00

10-01-28

170

Quality Control

QC3- Inspect Part Finish

Memo

0.00 0.00 BR 10-01-08.



W/O:	T	WORK ORDER CHANGES										
DATE	STEP	PI	PROCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	:	PAR #:	Fault Category:	NCR: Ye	es No <b>DQ</b>	A:	Date: _					
	Re	esolution:	Disposition:	QA: N/C	Closed:		Date: _					
NCR:			WORK ORDER NON-CON	IFORMANCE (N	CR)							

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector		
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				. •						

#### Work Order ID 55033



Page 4

January 5, 2010 1:21:50 PM

Item ID:

D3928-1

Accept

Setup Start



Revision ID:

Item Name:

Bracket

05/01/2010

Start Qty: 8.00 Red Qty: 8.00

Cust Item ID: Custosper:

Reference:

**Start Date:** 

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start

Stop



Required Date: 15/01/2010

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/ Work Center ID

180

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

**Run Hours** 

Draw Number

Plan Rev. Code

Accept Qty

Run

Reject

Reject Stamp Number

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



Quality Control

0.00

10-2-3

Dart Aerospace Ltd	<b>d</b>
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W/O:

W/O:		•••	WORK ORDER CHANGES							
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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		1881								
Part No	:	PAR #:	Fault Category:	NCR: Y	es No DC	A:	Date: _	<del></del>		
	Resol	ution:	Disposition:	QA: N/C	Closed:		Date: _	· · · · · · · · · · · · · · · · · · ·		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Description of NC Corrective Action Section B Ver			Verification Approval		Annual			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			

# **Picklist Print**

January 5, 2010 1:21:54 PM

Work Order ID: 55033

Parent Item: D3928-1

Parent Item Name: Bracket

Comments:

Replacement Mfg/ Component Item ID/ Item ID Item Name Purch

Purchased

M6061T6S.050

6061-T6 .050 Sheet



Start Date: 05/01/2010

Required Date: 15/01/2010

Page 1

Start Qty: 8.00

Required Qty: 8.00

Bin Item	Primary Location	Last Location	Route Seq ID	Unitedi Measure		Remaining Qty To Pick	Qty Issued	Date Issued	Status
No			100	sf	110.5716	0.6189	2.7	B 10-1-1	(

Warehouse	Loc Qty	Loc Code		
Location				
Main Warehouse				
MAT	110.5715			
110791	34.5715		WI 14 A STORY OF THE STORY OF T	(26)
113216	74			
17349	2		<del></del>	
112567			112567	

W/O:		V	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto			
Part No	:	PAR #:Fault Ca	tegory:N	CR: Yes	No <b>DQ</b>	A:	_ Date: _				

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:			WORK ORD	ER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Annuavai	A
DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Chief Eng Date		Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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				**************************************				
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DART AEROSPACE LTD	Work Order:	55033
Description: Bracket	Part Number:	D3928-1
Inspection Dwg: D3928 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

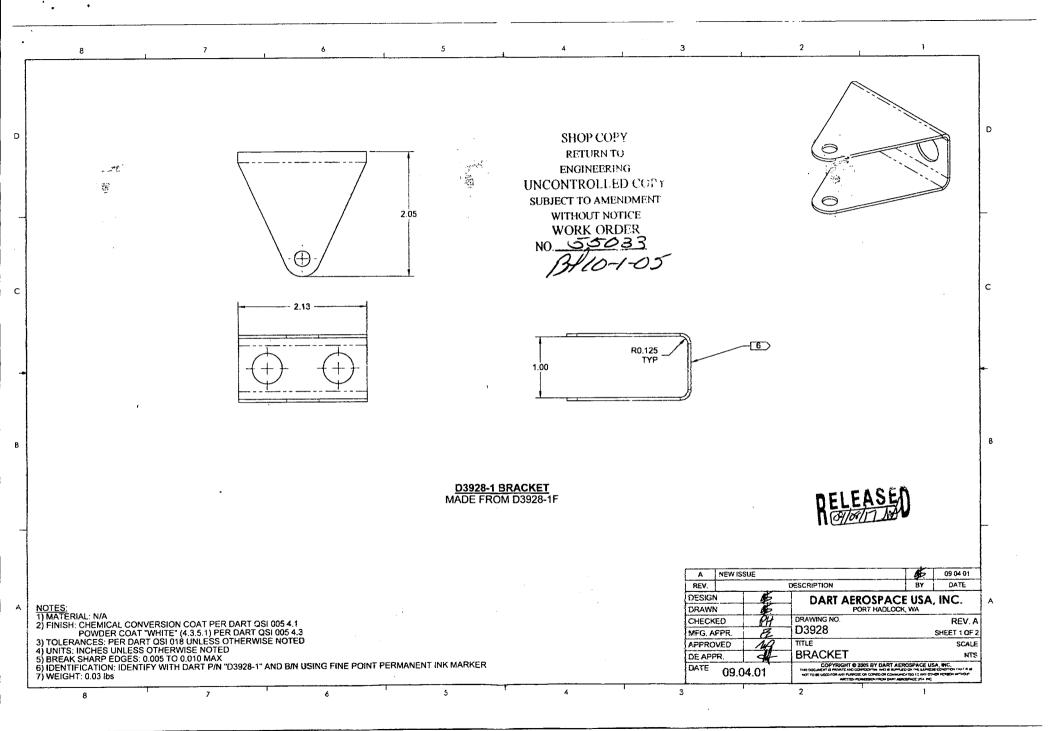
Drawing Dimension	Tolerançe	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Ø0.500	+0.006/-0.001	. 503	<b>&gt;</b>			
0.59	+/-0.030	, 060	×			
1.180	+/-0.010	1.182	۷			
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Measured by:	B	Audited by:	8	Prototype Approval:	N/A
Date:	10-1-11	Date:	colocl13	Date:	N/A

Rev	Date	Change	Revise	d by	Approved
Α	09.09.15	New Issue	KJ S	7	

Dart Ae	rospace	e Ltd						• • •			
W/O:			WORK ORDER CHANGES								
DATE	STEP	PF	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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·		PAR #:	Fault Category:	NCR: Yes No DQA:			Date:				
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NCR: WORK ORDER NON-CONFORMANCE (NCF							
	Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector
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W/O:			WORK ORDER CHANGES								
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Resolution:		n:	Disposition:	QA: N	QA: N/C Closed:				_ Date:		

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
DATE		Description of NC		Corrective Action Section B		Verification	A					
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
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Į.												
NOTE: D	ı ate & initia	al all entries		76	1			<u> </u>				

: تقسون 72 R0.30 0.59 TYP 1.180 2.13 GRAIN DIRECTION Ø0.257 25° TYP 2 PL Ø0.500 2 PL 0.61 0.050 REF

D3928-1F BRACKET FLAT PATTERN

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.059)

OR AMS 4025 OR AMS 4027 (REF DART SPEC M03611 2) FINISH: N/A 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: 0.03 lbs

8

DART AEROSPACE USA, INC. DESIGN DRAWN DRAWING NO. CHECKED REV. A D3928 SHEET 2 OF 2 MFG. APPR. APPROVED TITLE SCALE **BRACKET** NTS DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.

INSTITUTE OF THE TOP DATE 09.04.01

5

3

W/O:								
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		DAD #-	Foult Catagory	NCD: Voc	No DO	۸.	Dotos	

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	
Resolution: _		Disposition:	QA: N/C Closed	d:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE STEP	Description of NC		Corrective Action Section B			Approval	Approval				
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector			
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